

Work Order ID 109592

April-15-14 10:42:32 AM

D212-722-011

109592

Page 1

Now

Item ID: D212-722-011

B109592

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Avionics Riser Console

Start Date: 4/15/14 Start Qty: 7.00

7

Cust Item ID:

Required Date: 4/29/14 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 14-04-15

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3363	Rev C
DSI9476	A
IIN-D212-722	A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D212-722-011 CHG003

DAS
06
-89

JUN 19 2014

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360
Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall

2-Cut (1) D3361-1 to length as per Dwg D3361
Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr

7x

DAS
36
9-89
14/05/22

Work Order ID 109592

April-15-14 10:42:32 AM

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Page 2

Item ID: D212-722-011 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Avionics Riser Console

Start Date: 4/15/14 Start Qty: 7.00 *7* Cust Item ID:

Required Date: 4/29/14 Req'd Qty: 7.00 *7* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Chemical Conversion Coat per QSI005 4.1	0.00				7			
120									
HandFinish	Memo	0.00							
Hand Finishing									
130	QC7-Inspect Chemical Conversion Coat	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
36
9-89

Work Order ID 109592

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April-15-14 10:42:32 AM

Item ID: D212-722-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Avionics Riser Console
 Start Date: 4/15/14 Start Qty: 7.00 *7* Cust Item ID:
 Required Date: 4/29/14 Req'd Qty: 7.00 *7* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Small Fab	0.00				7x			14/05/26
140	Small Fab	0.00							
Small Fab	Memo								
	1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rai								
	1***Mount Dzus Rails to DT8957 (Radio) and transfer drill into console.****								
	2-Rivet D3360-1/-3/-5 & D3361-1 & D3362-1 as per Dwg D3363								
	Identify as D3363-041								
	ATTN: INSTALL D3362-1, AND MAKE SURE THE RADIO THAT IS								
	INSTALLED AT THIS PLACE FITS PRIOR TO CONTINUING TO MAKE								
	HOLES.								
150	QC5- Inspect part completeness to step on W/O	0.00				7			
150	QC	0.00							
Quality Control	Memo								

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DAS
27
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14/5/26

Work Order ID 109592

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April-15-14 10:42:33 AM

Item ID: D212-722-011 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Avionics Riser Console
 Start Date: 4/15/14 Start Qty: 7.00 *7* Cust Item ID:
 Required Date: 4/29/14 Req'd Qty: 7.00 *7* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212-722-011								

14/05/2014 (7) DAS 32 9-89

710Z 6 1 NMT

DAS 06 9-89

Change All Place
 FL 020
 Rev F

DAS 06 9-89

710Z 6 1 NMT

Work Order ID 109592

April-15-14 10:42:33 AM

109592

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Item ID: D212-722-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Avionics Riser Console

Stop *NS2*

Start Date: 4/15/14 Start Qty: 7.00

7

Cust Item ID:

Required Date: 4/29/14 Req'd Qty: 7.00

7

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

100

QC

Memo

0.00

Quality Control

14/6/23
MF
14-6-19

Picklist Print

April-15-14 10:42:36 AM

Page 1

Work Order ID: 109592

109592

Parent Item: D212-722-011

D212-722-011

Parent Item Name: Avionics Riser Console

Start Date: 4/15/14

Required Date: 4/29/14

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:B05.04.11 Now made at DartKJ/JLM
IPP Rev:C 07-06-09 Holes now Transfer drilled JLM IPP
REV:D 14.02.05 ADDED D212-722-013 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

PFSC35-38A		Purchased	No			100	Each	56.0000	8	56			
------------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

PFSC35-38A

Dzus 1/4 Turn Fastener

Location	Loc Qty	Loc Code
----------	---------	----------

ST391	56	
m128546	56	

M6063T5A0.750W.063	Purchased	No			110	f	74.8421	6.9				
--------------------	-----------	----	--	--	-----	---	---------	-----	--	--	--	--

M6063T5A0 750W 063

Angle6063T5 .750 X.750 X.063w

Location	Loc Qty	Loc Code
----------	---------	----------

MAT	74.8421052	
m128252	74.8421052	

M6063T5C.75X.75W.125	Purchased	No			110	f	25.0000	0.829				
----------------------	-----------	----	--	--	-----	---	---------	-------	--	--	--	--

M6063T5C 75X 75W 125

6063 CHANNEL.750 X.750 X.125w

Location	Loc Qty	Loc Code
----------	---------	----------

MAT007	25	
112040	4	
m128254	21	

D3363-1	Manufactured	No			140	Each	0.0000	1				
---------	--------------	----	--	--	-----	------	--------	---	--	--	--	--

D3363-1

Console

B112511 (5x)
B111050 (2x)

M128046

51

37.667

6

5x 4.742

2x 1.658

7

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DAS
36
9-89

~~M128252~~

M129241 (13.333)

DAS
36
9-89

DAS
36
9-89

14/05/26

~~M128252~~

M129241

14/05/26

14/05/26

Picklist Print

April-15-14 10:42:36 AM

Page 2

Work Order ID: 109592

109592

Parent Item: D212-722-011

D212-722-011

Parent Item Name: Avionics Riser Console

Start Date: 4/15/14

Required Date: 4/29/14

Start Qty: 7.00

Required Qty: 7.00

MS20426AD4-5

Purchased

No

140

Each

1,233.000

44

308

MS20426AD4-5

RIVET

**

14/05/26

DAS
36
9-89

Location

Loc Qty

Loc Code

ST334

1233

6874

233

m125807

1000

89
219

PR35-1

Purchased

No

140

f

9.1679

0.3333

3

PR35-1

DZUS FASTENER RAIL

**

14/05/26

DAS
36
9-89

Location

Loc Qty

Loc Code

Mezz

9.1679

107913

0.8335

114504

8.3344

0.6666
0.6666
1.6665 2.3334

MS20426AD4-6

Purchased

No

170

Each

3,003.000

9

63

MS20426AD4-6

Rivet

**

14/05/26

DAS
36
9-89

Location

Loc Qty

Loc Code

MF4

126

124392

126

ST334

990

124392

990

ST336

1887

M128812

1887

M126474

634

DAS
36
9-89

D212-722-011 x 1 per Kit - 119289 x 2

19851 x 5

DAS
31
9-89

April-15-14 10:42:36 AM

Shop Packet Print

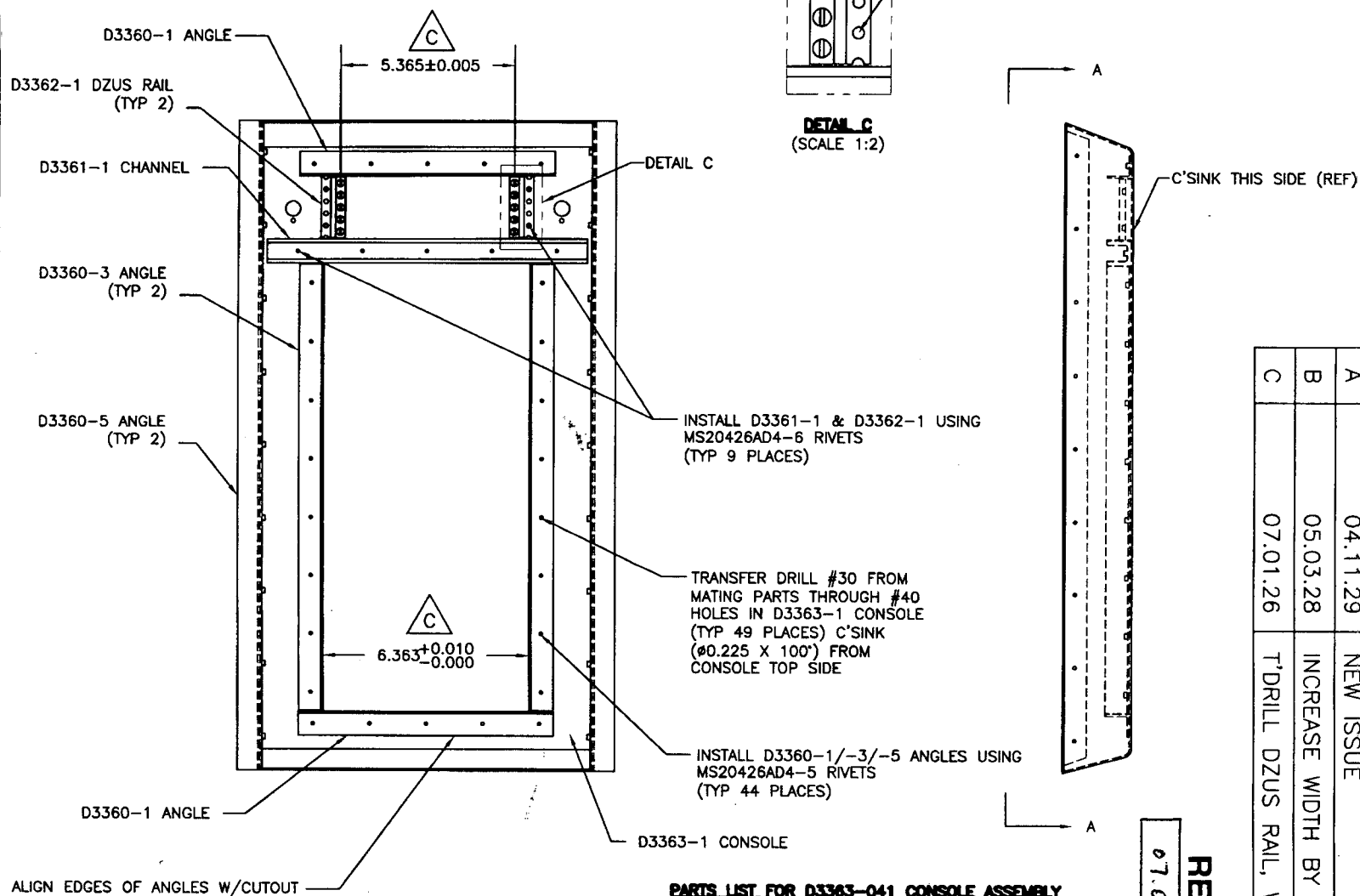
Page 2

109.592 MJS 14-04-15

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VIEW A-A FROM UNDER CONSOLE ASSEMBLY

PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY -041	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

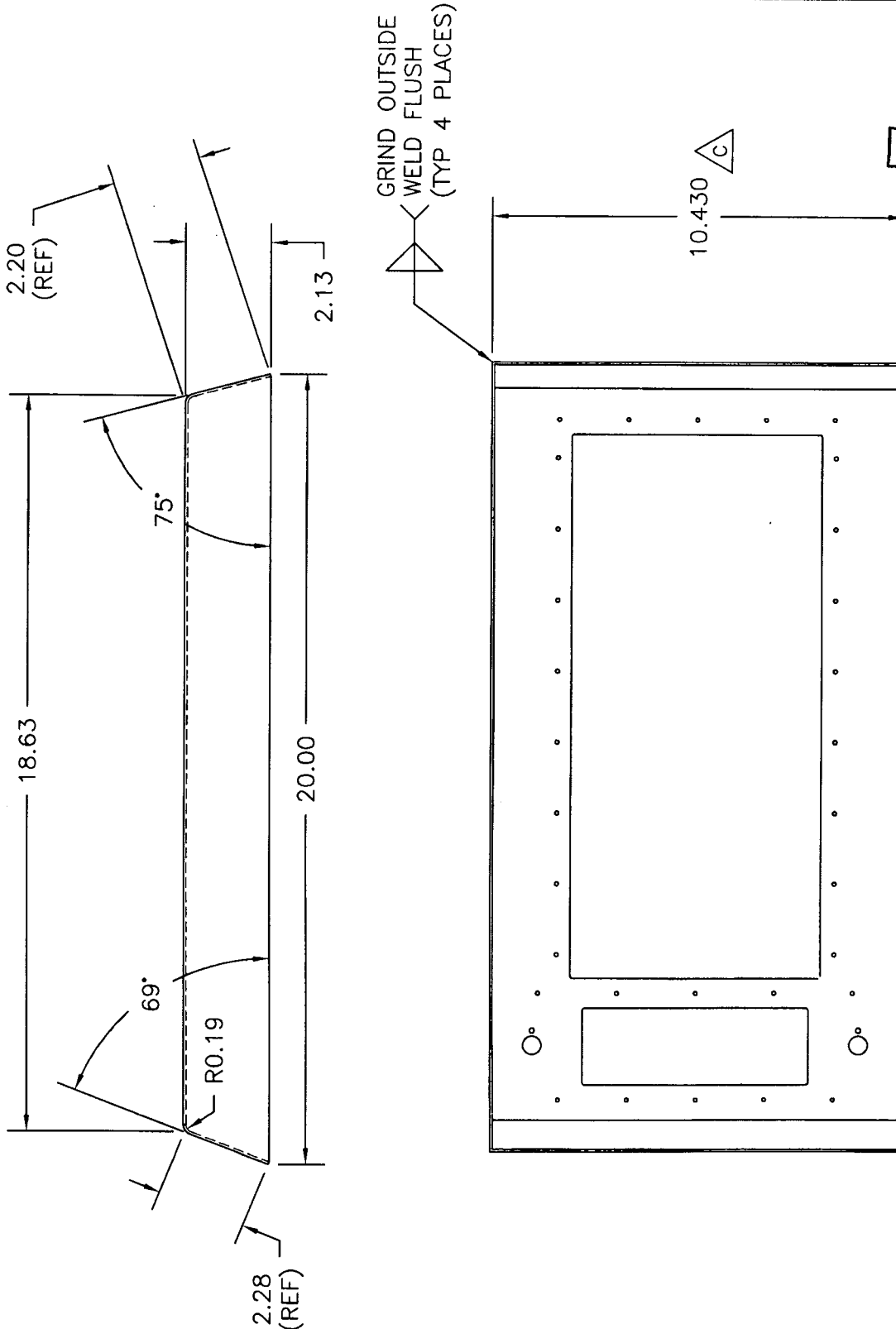
DESIGN	P41	DRAWN BY	P41	DART AEROSPACE LTD HAVERSBURY, ONTARIO, CANADA
CHECKED	15	APPROVED	15	REV. C
DATE	07.01.26	TITLE	CONSOLE ASSEMBLY	SHEET 1 OF 3
				SCALE 1:5
A	04.11.29	NEW ISSUE		
B	05.03.28	INCREASE WIDTH BY 0.125		
C	07.01.26	T'DRILL DZUS RAIL, WIDEN BASE CUTOUT		

RELEASED

07.06.04

DART

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4

**D3363-1 BEND DETAIL**

(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

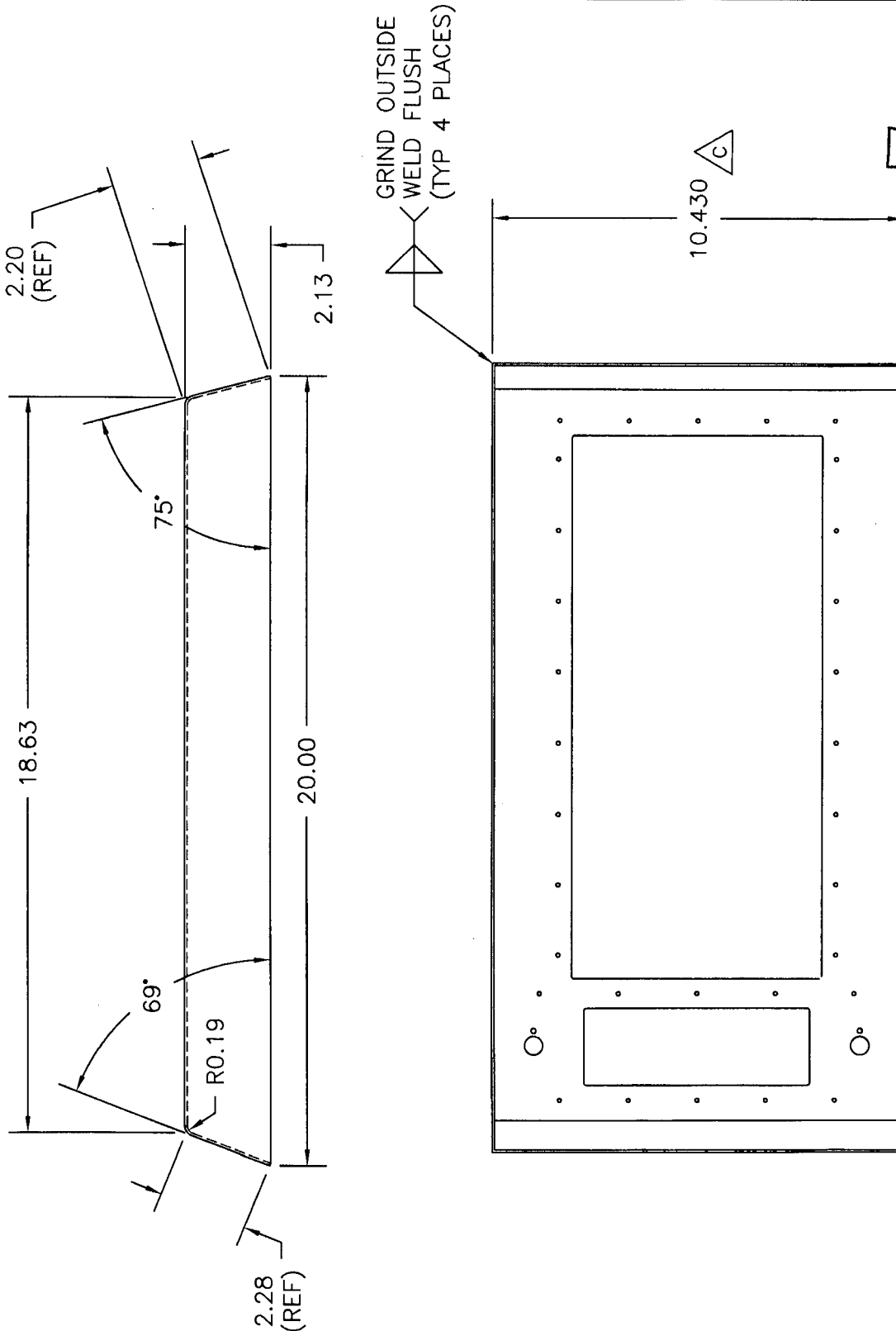
- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3363	REV. C SHEET 2 OF 3
DATE 07.01.26	TITLE CONSOLE ASSEMBLY		SCALE 1:4

**D3363-1 BEND DETAIL**

(MAKE FROM D3363-1F FLAT PATTERN)

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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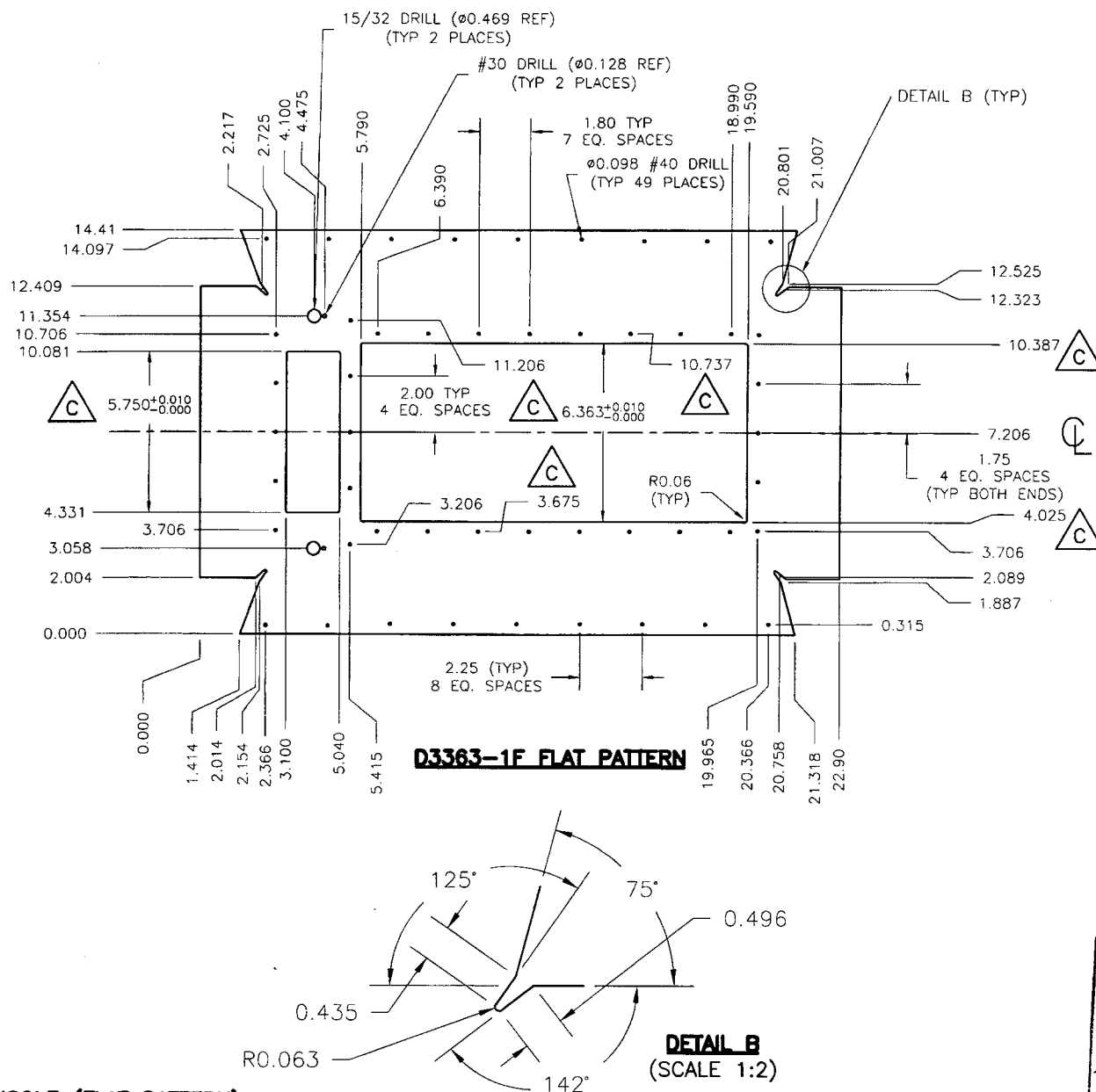
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DESIGN	DRAWN BY	DART AEROSPACE LTD
24	GH	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
13	GH	D3363
DATE	TITLE	SHEET 3 OF 3
07.01.26	CONSOLE ASSEMBLY	SCALE 1:6

RELEASED

07.06.04



D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-722 REV. A

REF. TCCA STC: SH05-11
REF. FAA STC: SR02091NY
REF. EASA IM.R.S.01181

The purpose of the Service Instruction is to provide instructions for the installation of the D212-722-013 Dzus Rail Brace Kit which has been developed to provide a fastening method for the center dzus rail when the D212-722-011 Avionics Riser Console is installed. The D212-722-013 kit has been added to all D212-722-011 kits at CHG 003 or later.

If the aircraft pedestal has been removed from the aircraft follow the instructions in Option 1. If the pedestal has not been removed from the aircraft follow instructions in Option 2 (Sheet 2).

The maximum weight of equipment installed in front of the D212-722-011 Avionics Riser Console using the D212-722-013 Kit is 40 lbs.

Option 1 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to the correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the existing center PR35 dzus rails.
- 2) Remove the existing center dzus rail braces.
- 3) Clamp the D3986-1 angle, D3986-3 braces and PR35 dzus rail together as shown in Figure 1 (Sheet 3). The D3986-3 braces should be approximately centered between the existing dzus rails.
- 4) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 5) Transfer drill 9x $\varnothing 0.129$ (#30 drill) holes from PR35 dzus rail thru D3986-3 braces. See Figure 2, (Sheet 4), Note 1.
- 6) Deburr holes and reassemble using clecos.
- 7) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 2, (Sheet 4), Note 2.
- 8) Deburr holes and reassemble using clecos.
- 9) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from aircraft pedestal to D3986-3 braces. See Figure 2, (Sheet 4), Note 3.
- 10) Deburr holes, dimple D3986-3 brace and aircraft pedestal and reassemble using clecos.
- 11) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft pedestal. See Figure 2, (Sheet 4), Note 4.
- 12) Deburr holes, dimple D3986-1 angle and aircraft pedestal and reassemble using clecos.
- 13) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails.
- 14) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 2 (Sheet 4) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

A	NEW ISSUE		11.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	11.06.01		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. DSI 9476	REV. A SHEET 1 OF 7
		TITLE DZUS RAIL BRACE KIT	SCALE NTS
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Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.






PARTS LIST

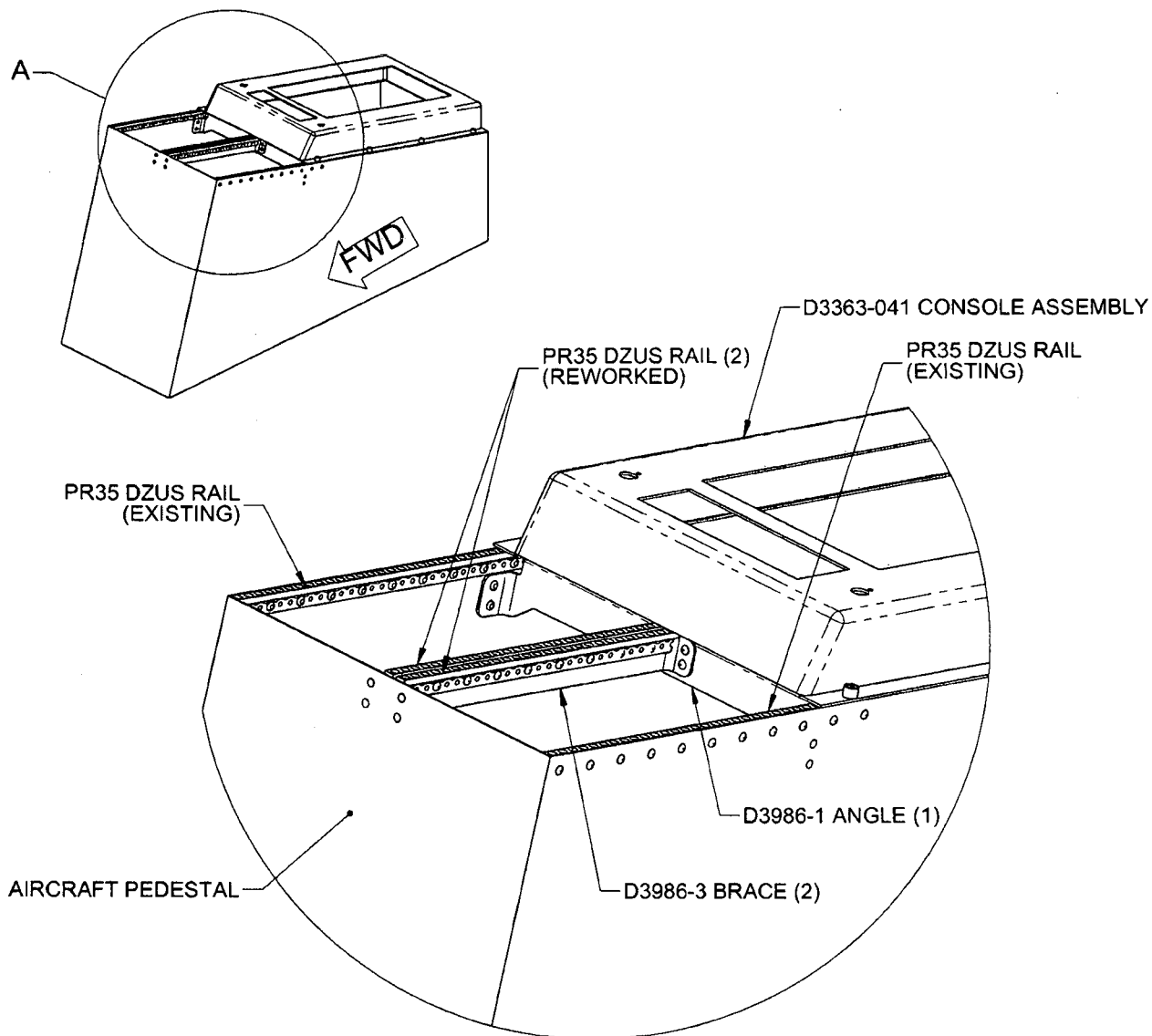
QTY. -013	PART NUMBER	DESCRIPTION
X	D212-722-013	DZUS RAIL BRACE KIT
1	D3986-1	ANGLE
2	D3986-3	BRACE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9476	SHEET 2 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DZUS RAIL BRACE KIT	NTS
DATE	11.06.01	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



DETAIL A

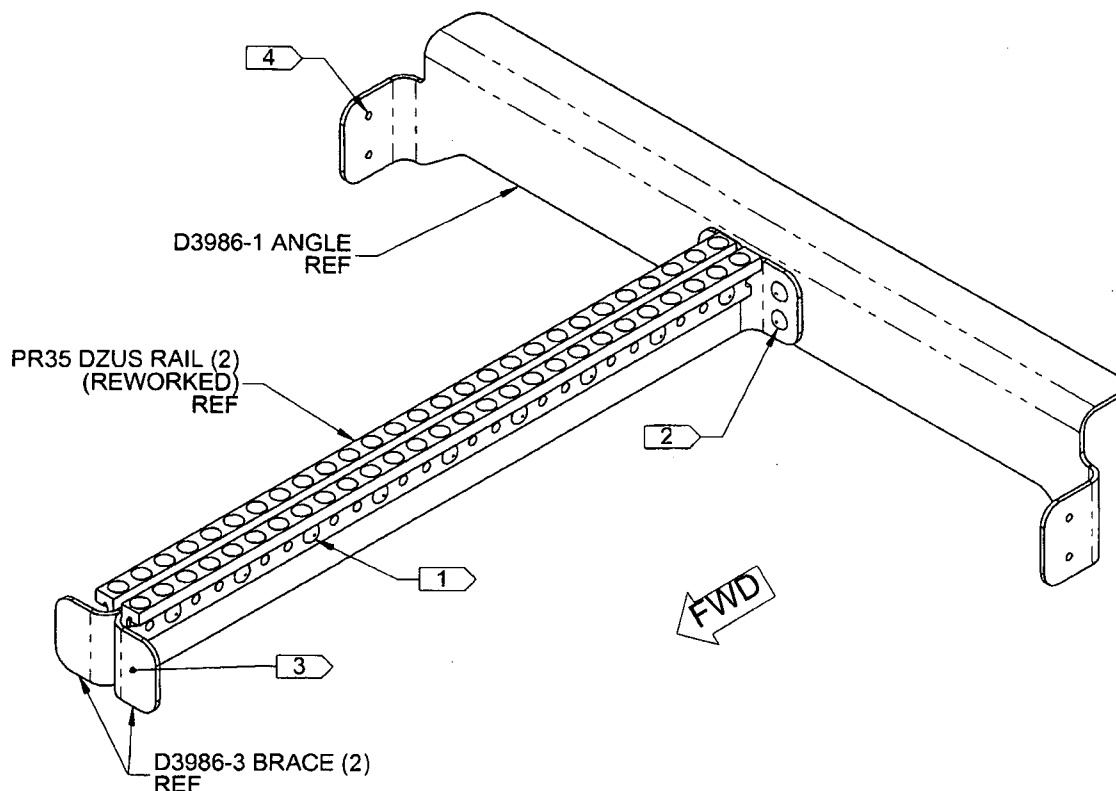
FIGURE 1: D212-722-013 DZUS RAIL BRACE INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9476	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	DZUS RAIL BRACE KIT	NTS
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- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM AIRCRAFT CONSOLE TO D3986-3 BRACES. DIMPLE D3986-3 BRACES AND INSTALL MS20426AD4 RIVETS, 4 PL.
- 4) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL






FIGURE 2: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 1
(PEDESTAL REMOVED FROM AIRCRAFT)

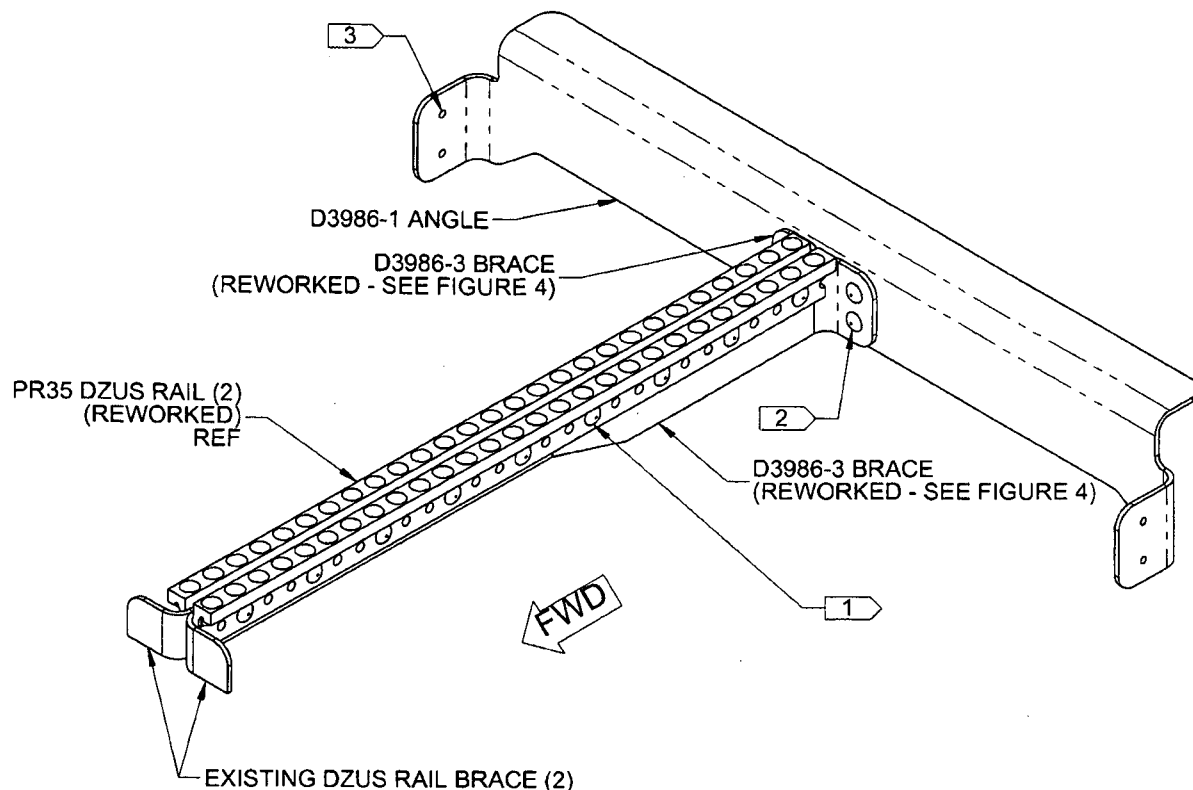
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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY: *[Signature]*
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- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL (4 PL TYP) $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL

FIGURE 3: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 2
(PEDESTAL NOT REMOVED FROM AIRCRAFT)

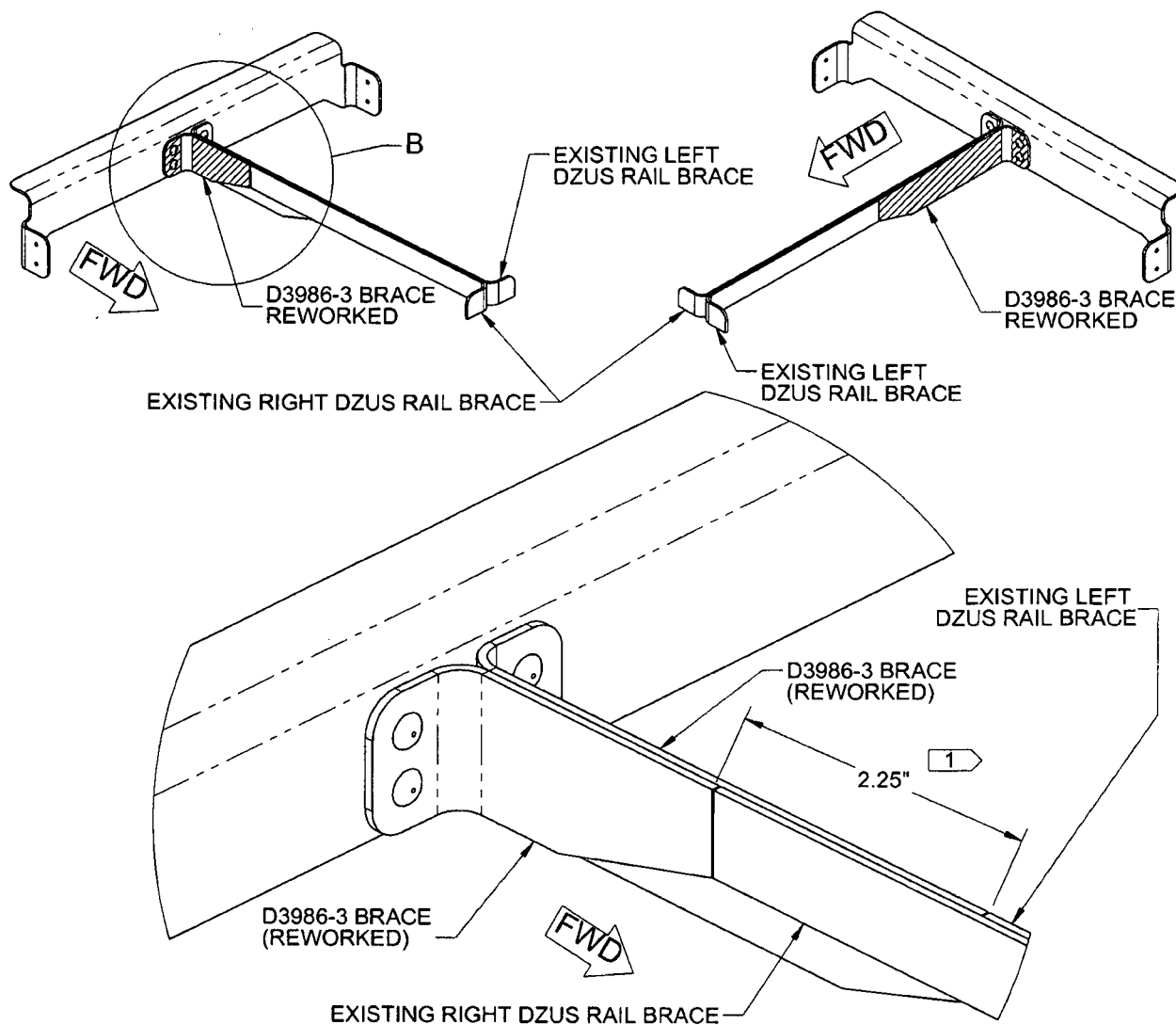
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DETAIL B

- 1) TRIM EXISTING LEFT DZUS RAIL BRACE SO THAT THE END IS HALF WAY BETWEEN EXISTING RIVET HOLES. TRIM EXISTING RIGHT DZUS RAIL BRACE 2.25" LONGER






FIGURE 4: EXISTING DZUS RAIL BRACE TRIMMING DETAIL - OPTION 2
(REWORKED DZUS RAILS AND RIVETS NOT SHOWN FOR CLARITY)

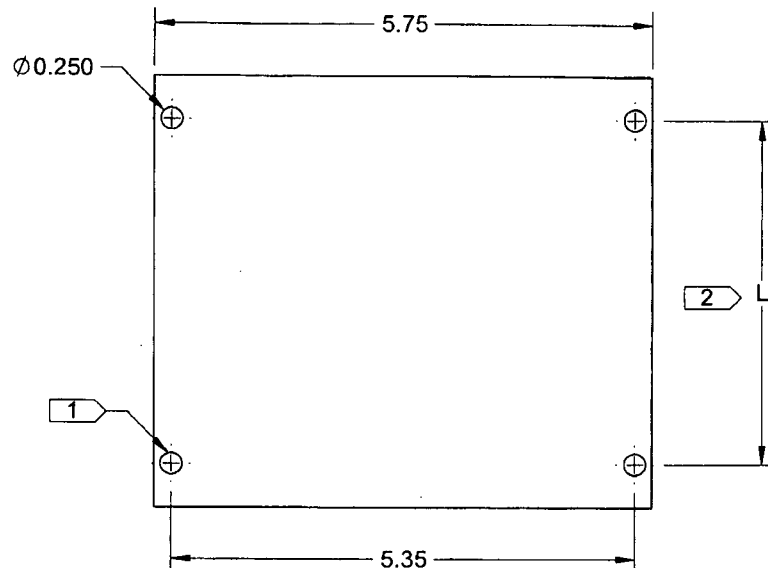
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- 1) INSTALL DZUS FASTENERS, 4 PL TYP
- 2) DIMENSION "L" IS MIN 4". MUST BE DIVISIBLE BY 0.375






FIGURE 5: BLANKING PLATE

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Work Order ID 109592

April-15-14 10:42:32 AM

D212-722-011

109592

Page 1

Item ID: D212-722-011

B109592

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Avionics Riser Console

Stop

NS2

Start Date: 4/15/14

Start Qty: 7.00

7

Cust Item ID:

Required Date: 4/29/14

Req'd Qty: 7.00

7

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 11-04-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3363

Rev C

DSI9476

A

IIN-D212-722

A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control-USB or Paperwork

Photocopy bluefile and create labels per PPP D212-722-011 CHG003

110

110

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360
Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall

2-Cut (1) D3361-1 to length as per Dwg D3361

Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Debur

MLS 11-05-15

7

7x

DAS 36 9-89 14/05/22